

Work Order ID 148588

Tuesday, July 05, 2016 3:09:07 PM

148588

Page 1

Item ID: D2269

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Placard

Start Date: 6/27/2016 Start Qty: 8.00

8

Cust Item ID:

Required Date: 7/5/2016 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: **DAS**Date: **JUL 12 2016**

Tooling:

Date:

Run Start ***NR1***QC: **21**
9-89

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2269

Rev B1

100

0.00

100

Purchasing

PURCHASING

Memo

0.00

Purchasing

Issue P/O: **33006** Make per Dwg D2269 Manufacture from 3M 7mil
masking film p/n 8522CP or Avery IPM no.2031 Material release note required**8** **JUL 13 2016** **DAS**
13
9-89

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.03

Packaging

Ensure material release note is attached

8x SP16-720

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

8 **JUL 21 2016** **DAS**
38
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : _____					

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Page 2

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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>006</u>	0.00							
130						<u>8</u> DAS			
Packaging	Memo	0.01				<u>8</u>			
Packaging	***ONE YEAR EXPIRED DATE FROM RECEIVING: _____***					<u>9-89</u>			JUL 22 2016
	JUL 22 2017								
140	QC21- Final Inspection - Work Order Release	0.00							
140							DAS		JUL 22 2016
QC	Memo	0.13					<u>21</u>		
Quality Control							<u>9-89</u>		

DAS
21
9-89
JUL 22 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Picklist Print

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Page 1

Work Order ID: 148588

148588

Parent Item: D2269

D2269

Parent Item Name: Placard

Start Date: 6/27/2016

Required Date: 7/5/2016

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: B 01.04.09 Re-format EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2269P *D2269P* Placard		Purchased	No			100	Each	0.0000	1	8			

**

8x 8P/6-7-20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval				
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Root Cause				FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
				OTHER : _____							



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	MIKE M	DRAWING NO.	REV. B
CHECKED	APPROVED	D2269	SHEET 1 OF 1
DATE	TITLE	SCALE	
96:05:27	PLACARD	1:1	
B	96.05.29	UPDATED PLACARD	
B1	01.04.10	ADD MATERIAL NOTE # CP	

WHEN COMPARTMENT EXTENSION IS USED
MAXIMUM COMBINED LOADING OF EXISTING
COMPARTMENT AND EXTENSION IS NOT
TO EXCEED 72 Kg. (158lb.)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
100-100-588 M.C.S.
16-07-12



MATERIAL: BLACK LETTERS ON WHITE ADHESIVE BACK
MANUFACTURED FROM 3M 7 MIL MASKING FILM #8522CP



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO33006

Purchase Order Date 7/13/2016

PO Print Date 7/13/2016

Page Number 2 of 4

Order From :

STUDIO DE LETTRAGE 2001
210 MAIN WEST
HAWKESBURY, ON K6A 2H6
CA

VC-STU001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613 632 5449

Ship To Contact

Ship To Phone

Ship Via: Yours ppd

Ship Acct:

Buyer

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB Destination-Collect

Line Total: \$80.00

4 D2269P

Placard

7/18/2016

Yes

7/18/2016

8.00
Each

\$10.00

\$80.00

AS PER DWG D2269 REV. B
B148588

Sp/16-7-20

Line Total: \$80.00

5 D4086-220P

Placard, Max Load

7/18/2016

Yes

7/18/2016

6.00
Each

\$13.33

\$80.00

AS PER DWG D4086 REV. B
B148846

Line Total: \$80.00

6 D3012-1P

Decal

7/18/2016

Yes

7/18/2016

10.00
Each

\$8.00

\$80.00

AS PER DWG D3012 REV. A
B148820

Note:

7/13/2016

STUD!O

210 Main Street West
Hawkesbury, ON K6A 2H6
Phone # 613-632-2001

Invoice.

Date	Invoice #
7/18/2016	42749

Invoice To

Dart Aerospace Ltd
1270 Aberdeen
Hawkesbury
Ontario
K6A 1K7

Ship To

P.O. No.	Terms	Rep	Ship	Via	F.O.B.	Project
33006			7/18/2016			

Quantity	Item	Description	Price Each	Amount
5	4005	D3569-3P	16.00	80.00
6	4005	D2258-200P	13.33333	80.00
6	4005	D2268P	13.33333	80.00
8	4005	D2269P	10.00	80.00
6	4005	D4086-220P	13.33333	80.00
10	4005	D3012-1P	8.00	80.00
6	4005	D3268-1P	13.33333	80.00
6	4005	D4621-1P	13.33333	80.00
8	4005	D5409-1P	10.00	80.00
8	4005	D5409-3P	10.00	80.00
		WO: 18298		

Spl6-720

Subtotal \$800.00

Thank you for your business.

Sales Tax \$104.00

Total \$904.00

******CERTIFICATE of CONFORMITY******

Customer:

Studio LeHrage.

Purchase Order N°:

33006

Packing Slip N°:

WO # 18298

Part N°:

Serial N°:

Description:

D2269-3P, D2258-200P,
D2268R, D2269P, D4086-220P, D3012-1P,
D2268-1P, D4621-1P, D5409-1P, D5409-3P

Quantity:

69

Certification:

We hereby certify that:

1. The above listed items were manufactured, repaired and/or inspected in accordance with applicable drawings and/or specifications;
2. All work was accomplished in accordance with the Dart Aerospace Purchase Order;
3. Results of all inspections, chemical or physical tests, as well as other evidence, which shows the acceptability of raw materials, parts and/or assembly components are on file and available for inspection at any time.

Authority:

Avery

APPROVAL:

Valerie Young

Signature:

Val J

Title:

office administrator

DATE:

July 19.16

PRODUCT DATA SHEET



Avery® IPM I™ 7112

issued: 15/04/2002

Introduction

Avery IPM I 7112 is a white monomeric calendered removable self-adhesive vinyl for use on the Idanit 162Ad inkjet printer, providing good machine runnability. Because of its cost efficiency and good removability, Avery IPM I 7112 is recommended for a wide range of short term applications on flat substrates requiring easy and clean removal.

Description

Film : 100 micron gloss white monomeric calendered vinyl
Adhesive : **removable**, acrylic based
Backingpaper : kraft paper, 140 g/m²

Conversion

Avery IPM I 7112 is specially developed for use on the Idanit 162Ad and Idanit Novo inkjet printer and has been officially approved by Idanit using BL and Magic inks.

Uses

- Interior & exterior signs.
- Window decoration.
- Temporary promotional and point of sale advertising and all.
- applications to flat or regular surfaces that require removability.

Features

- Good printability and handling on Idanit 162Ad.
- Easy conversion.
- Most economical solution for short term outdoor graphics.
- Easy and clean removal (up to 1 year).



www.averygraphics.com

Graphics Division
Rijndijk 86, P.O. Box 118
2094 ZG Hazerswoude – The Netherlands
Tel +31 71 3421500 – Fax +31 71 3421508

PRODUCT CHARACTERISTICS

Avery® IPM I™ 7112

Physical properties

Features	Test method ¹	Results
Caliper, facefilm	ISO 534	100 micron
Opacity	ISO 2471	92%
Dimensional stability	DIN 30646	0.3 mm max.
Adhesion, initial	FINAT FTM-1, stainless steel	225 N/m
Adhesion, ultimate	FINAT FTM-1, stainless steel	400 N/m
Flammability		Self extinguishing
Shelf life	Stored at 22° C/50-55 % RH	2 years
Removability		up to 1 year*
*Not when applied to: Nitrocellulose paints, ABS, Polystyrene, screenprinting inks (fresh), certain types of PVC		
Durability, unprinted	Vertical exposure	2 years

Temperature range

Features	Results
Minimum application temperature:	≥ 0° C
Temperature range:	- 40 to +100 °C

Important

Information on physical and chemical characteristics is based upon tests we believe to be reliable. The values listed herein are typical values and are not for use in specifications. They are intended only as a source of information and are given without guarantee and do not constitute a warranty. Purchasers should independently determine, prior to use, the suitability of this material to their specific use. All technical data are subject to change.

Warranty

Avery® branded materials are manufactured under careful quality control and are warranted to be free from defect in material and workmanship. Any material shown to our satisfaction to be defective at the time of sale will be replaced without charge. Our aggregate liability to the purchaser shall in no circumstances exceed the cost of the defective materials supplied. No salesman, representative or agent is authorised to give any guarantee, warranty, or make any representation contrary to the foregoing.

All Avery® branded materials are sold subject to the above conditions, being part of our standard conditions of sale, a copy of which is available on request.

1) Test methods

More information about our test methods can be found on our website.

2) Durability

The durability is based on middle European exposure conditions. Actual performance life will depend on substrate preparation, exposure conditions and maintenance of the marking. For instance, in the case of signs facing south; in areas of long high temperature exposure such as southern European countries; in industrially polluted areas or high altitudes, exterior performance will be decreased.



www.averygraphics.com

Graphics Division

Rijndijk 66, P.O. Box 118
2394 ZG Hazerswoude - The Netherlands
Tel +31 71 3421500 - Fax +31 71 3421538